

Date: Thursday, 4/20/2006 9:58:25 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD X-TUBE EXT HEIGHT(-013)
Job Number : 24078	
Estimate Number : 10565	
P.O. Number : N/A	Part Number : D205596105
This Issue : 4/20/2006 S.O. No. : N/A	Drawing Number : D205596105
Prst Rev. : NC	Project Number : N/A
First Issue : 11/17/2005 Type : LANDING GEAR	Drawing Revision : A
Previous Run : 23463	Material : N/A
Written By : _____	Due Date : 4/21/2006 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:D 05.03.21 Added bending procedure KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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①

Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-105 CHG001

DA 05.09.21

2.0	D2889	FWD Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2889 Aft Crosstube

B19666

DP06-4-21

3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend D2890 as per Dwg D2889 and Folio FT001

DP06-4-24

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

DP06-4-24

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Deburr and Polish

DP06-5-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 9:58:25 AM
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Job Number:



Seq. #: Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Mark 23.92" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions. Conformity check and sign off by engineering.

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-105

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Back up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date
Use

Thursday, 4/20/2006 9:58:25 AM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 24078

Part Number: D205596105

Job Number:



Sq. #:

Machine Or Operation:

Description:

14.0

QC14

Inspect Spray Paint



Handwritten signature and date: 06-08-24

Comment: Inspect Spray Paint

15.0

D2856600

Abrasion Strip



Comment: Qty.: 1.4895 f(s)/Unit Total: 1.4895 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(8.51") Abrasion Strip

Handwritten: B24328

Handwritten: RT 06-09-05

16.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2893-11

Support

Handwritten: B24328 B23475

Handwritten: RT 06-09-05

17.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-24

Clamp

Handwritten: M100213

Handwritten: RT 06-09-05

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-105. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

Handwritten: RT 06-09-05

A/R Sikaflex -291

Expiry date:

Handwritten signature: N/A. J. J.

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: DP 6-9-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *DE* Date: 06/09/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 9:58:25 AM
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Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 24078

Part Number: D205596105

Job Number:



Seq. #: Machine Or Operation:

Description:

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-105

Location:

PPP Rev: C

PC

6/9/6 / (1)

21.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/09/06 (1)

Job Completion



LL 06-09-06

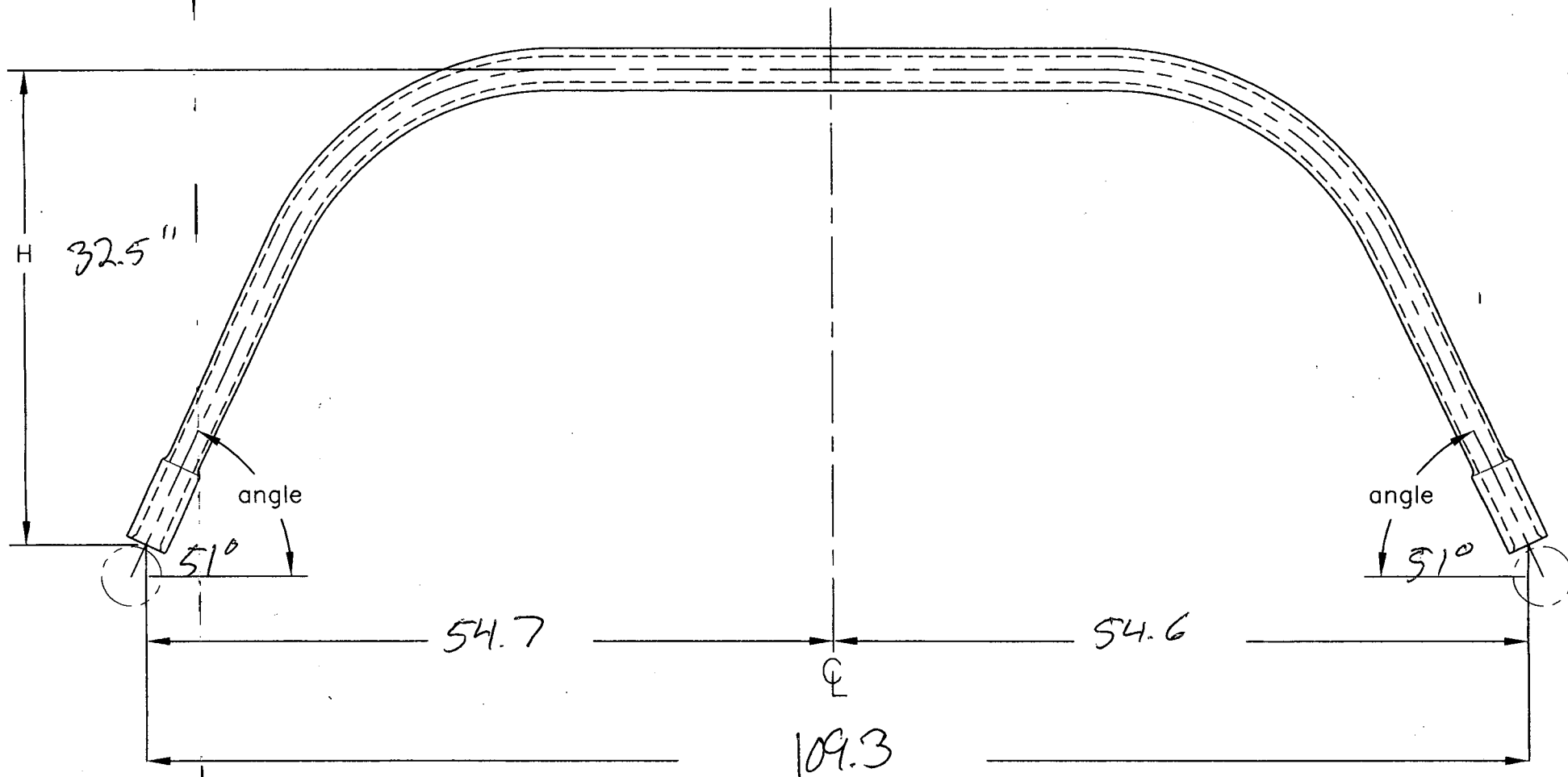
NOTE: Date & Initials
H-I FORMS Quality Assurance Approved OANCRMO RevD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



DATE: 05-05-05
 DESCRIPTION: D205-596-105
 BATCH NO: 24078
 DRAWING: D205-596-
 H: 32.5"
 1/2 SPAN: 54.6"
 TOTAL SPAN: 109.4"
 ANGLE: 50°

18 06-05-05

Date: Friday, 12/01/2007 3:03:24 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 30252

Estimate Number : 10804

P.O. Number : N/A

This Issue : 12/01/2007

Prsht Rev. : NC

First Issue : N/A

Previous Run : 30251

S.O. No. : N/A

Type : OVERHEAD

Drawing Name : D205-594 - ECN 904

Part Number : Z_CUSTOM

Drawing Number : UPDATE PAPERWORK

Project Number : N/A

Drawing Revision : N/A

Material : N/A

Due Date : 19/01/2007

Qty: 1 Um: Each

Written By

Checked & Approved By

Comment

Additional Product

Job Number:

Description :

Seq. #:

Machine Or Operation:

PACKAGING RESOURCE #1

1.0

PACKAGING 1

Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK
 EASA STC EASA.IM.R.S.01198

D205-596-101

D205-596-103

D205-596-105

D205-596-107

D205-596-109

B 238041 IX 21

B 24946, B 24078, B 26841 = 3

B 28663 1 =

FINAL INSPECTION/W/O RELEASE

2.0

QC21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion